

Date:
User:Monday, 9/11/2006 3:43:32 PM
Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP LH
Job Number	: 28479		
Estimate Number	: 10855		
P.O. Number	: N/A	Part Number	: D206628021
This Issue	: 9/11/2006	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: N/A
Previous Run	: 28053	Material	: N/A
Written By	: _____	Due Date	: 9/30/2006
Checked & Approved By	: <u>JA 06.09.12</u>	Qty:	4 Um: Each
Comment	: Est Rev: D as per ECN 766 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

06.09.15 KJS (4)

2.0 28479A 206L /407 STEP ASSY, LH



Comment: Sub-Component SUB-COMPONENT

D2724-041 B 28479A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D27317 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description

4 D2731-7 Mounting Lug

Batch

B22592 x 10, B27700 x 4, B25452 x 2

5.0 D2856400 Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total: 4.6830 f(s)

Pick:

Qty Part # Description

2 D2856-400 6.9" Abrasion Strip

Batch

B28258 ✓1306/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 28479

Part Number: D206628021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y

B27120x14 ✓

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-12A Bolt

M101390 ✓

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-13A Bolt

M101938 ✓

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt

M102039 ✓

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

M19185 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4)

M19099 ✓

B306/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 06/10/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 28479

Part Number: D206628021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Rec'd 10/20 43

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-021

Location: E

PPP Rev: E

Rec'd 10/20 3

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

3
06/10/23

Job Completion



C 206110/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, LH
Job Number	: 28479A		
Estimate Number	: 11702		
P.O. Number	: N/A	Part Number	: D2724041
This Issue	: 9/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2724 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28053A	Drawing Revision	: C
		Material	: N/A
Written By	:	Due Date	: 9/30/2006
Checked & Approved By	: <u>06.09.12</u>	Qty:	4 Um: Each
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>327077</u>

Check Material for any Dents or Defects

P.E. 06.09.13

4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

P.E. 06.09.13
P.E. 06.09.14

4

3.0	D2734	206 Step Endplate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>327281</u>

P.E. 06.09.14

4

4.0	D34581	PLATE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<u>327128</u>

P.E. 06.09.14

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 28479A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	327253

RE. 06.09.14

4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig
DT (One End Only)

A/R AL ROD Batch: M100660 M15689 M19612

Grind end cap welds flush

RE. 06.09.15

4

RE. 06.09.15

4

RE. 06.09.24

4

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

2006/09/25 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06/09/28 x4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Feb-10-10 (4)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT

A/R AL ROD Batch: M15689

RE. 06.10.11

4

RE. 06.10.11

4

RE. 06.10.11

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 28479A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Job 10-12 (4)

06/10/13 (4)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

Y

06/10/18 x4

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

Yon 06/10/18 x4

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 14 (4)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

Y 06/10/19 x4

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/10/20 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

MA

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/20 (4)

Job Completion



U 26.10.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

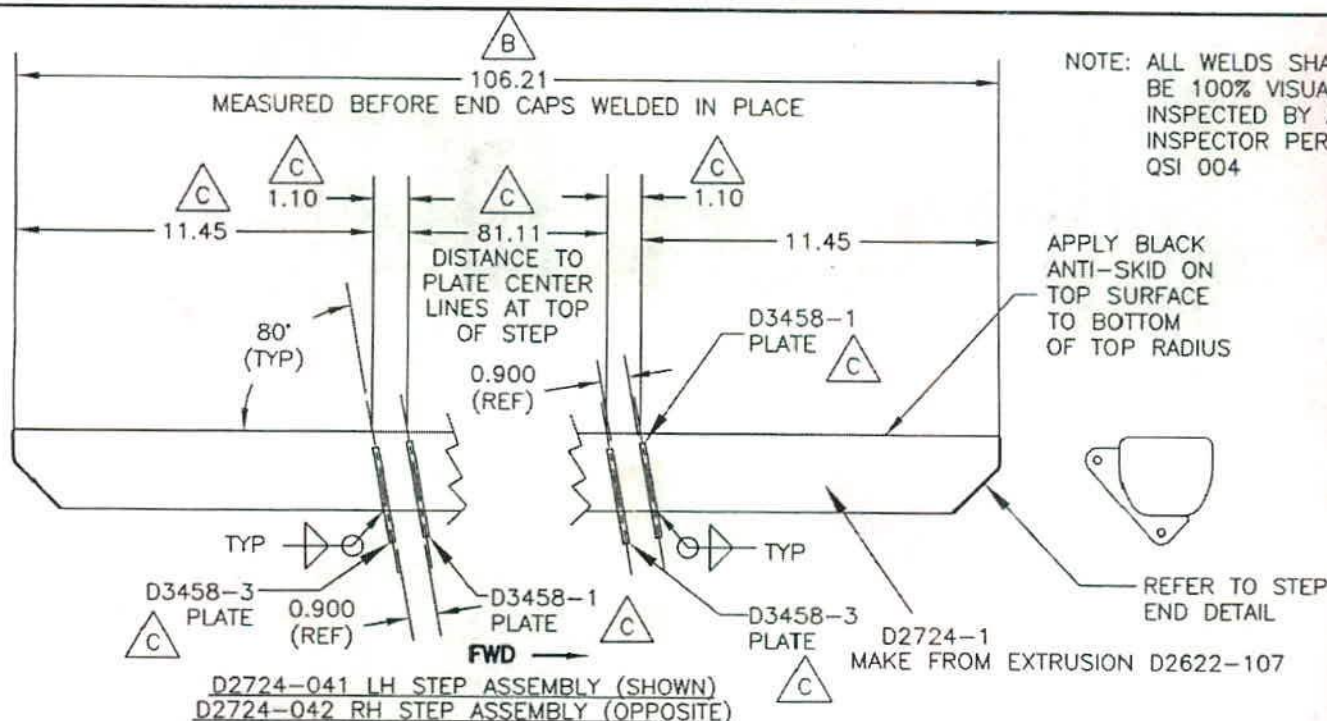
NOTE: Date & initial all entries

DART

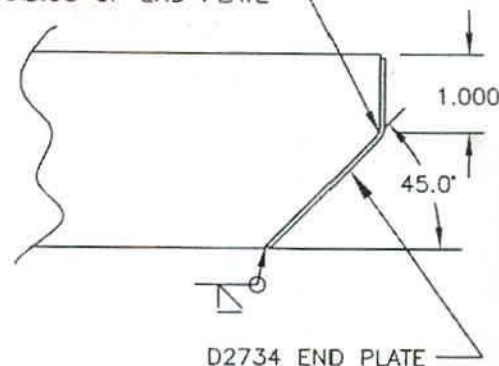
RELEASED

05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2724
DATE		TITLE
05.09.19		206L/407 STEP ASSEMBLY
		NEW ISSUE
		UPDATED WELD DETAIL REVISED TOLERANCES
		RE-DESIGN, ADD D3458-1/-3
		SCALE
		NIS
		SHEET 1 OF 1
		REV. C